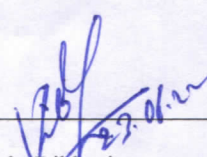


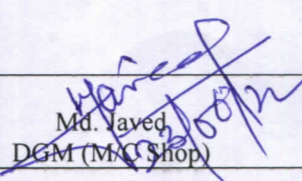
**MACHINING OF RUNNER SKIRT****Indent No- 20220082****i) PRE QUALIFICATION REQUIREMENT**

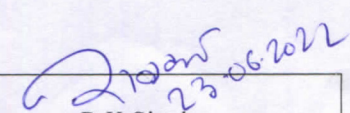
| S.No. | BHEL Requirement                                                                                                                                                                                                                                       | Vendor's Confirmation                                                                                            |
|-------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|
| 1     | Only those vendor should quote who have past experience of machining of similar job having max. dia. greater than 3000 mm and weight more than 15MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs) | Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer) |
| 2     | Vendor should have a Vertical Boring machine which can machine a job of dia. 5050 mm, height 1100 mm and weight 24MT                                                                                                                                   | Vendor to Confirm and submit detail                                                                              |
| 3     | Vendor should have material handling capacity of 24MT or more                                                                                                                                                                                          | Vendor to Confirm and submit detail                                                                              |

**ii) TECHNICAL REQUIREMENT**

| S.No. | BHEL Requirement                                                                                                                                               | Vendor's Confirmation |
|-------|----------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|
| 1     | Marking and Machining as per drawing no. 0-204-07-21203/M1:Rev-00                                                                                              | Vendor to confirm     |
| 2     | Vendor to arrange all tools, templates & instruments required for machining and checking of the job                                                            | Vendor to confirm     |
| 3     | Inspection of the machined job may be carried out by BHEL at vendor's works before despatch                                                                    | Vendor to confirm     |
| 4     | Delivery requirement: 6 weeks/pc from the date of lifting                                                                                                      | Vendor to confirm     |
| 5     | Identification details on the casting to be maintained                                                                                                         | Vendor to confirm     |
| 6     | Vendor to submit following with the offer:-<br>a) Details of the Organization<br>b) Details of the machine tools and other facilities installed in the company | Vendor to submit      |
| 7     | Vendor may plan a visit to CFFP for technical discussion.                                                                                                      | Vendor to Note        |
| 8     | BHEL team may visit vendor's works for facility/capacity verification.                                                                                         | Vendor to Accept      |

  
Vikalp Bibhuti  
Dy. Manager (M/C Shop)

  
Md. Javed  
DGM (M/C Shop)

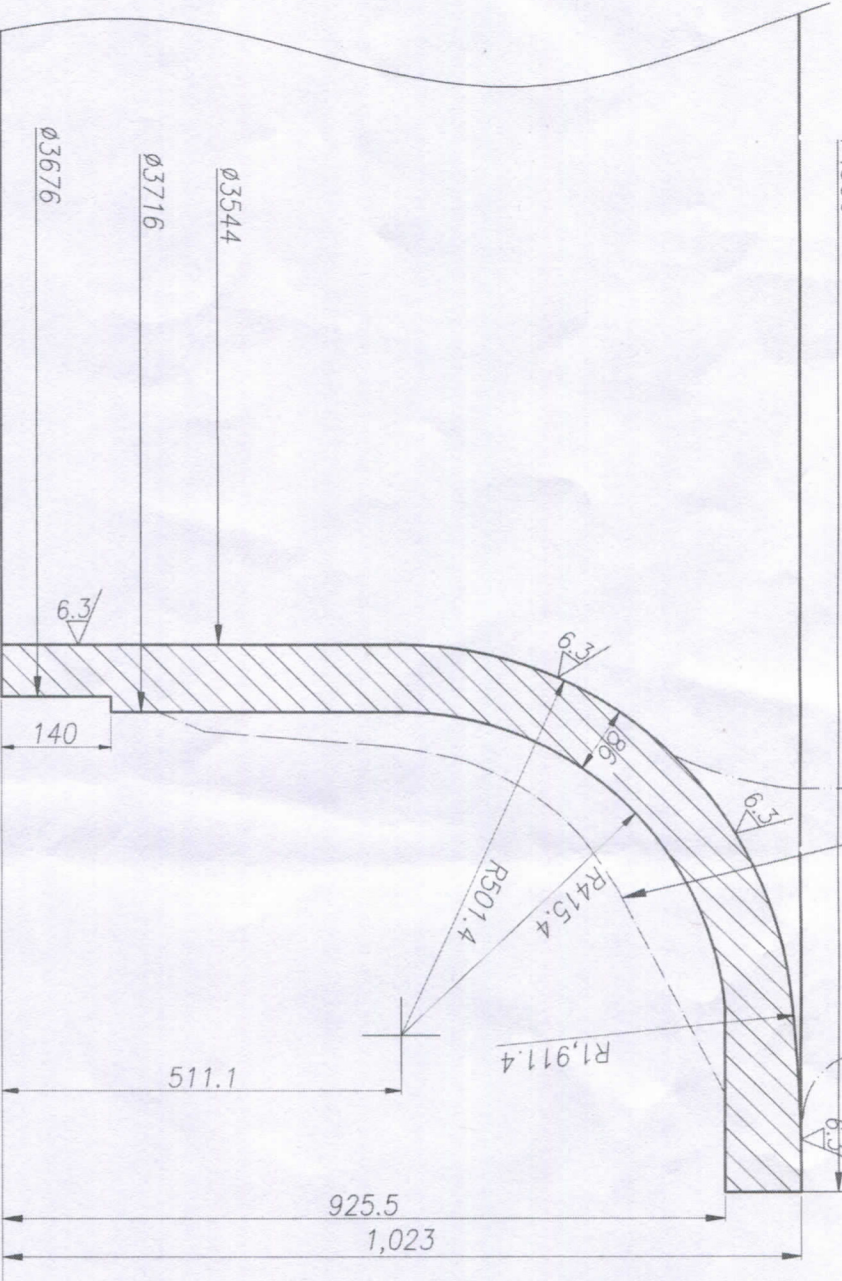
  
R.K. Singh  
AGM (M/C Shop)



Ø4956

CONTOUR OF CASTING BEFORE MACHINING

12.5/EXCEPT AT SHOWN



NOTE:-

1. CASTING TO BE ROUGH MACHINED TO THE DRG. DIMENSIONS ON ALL THE SURFACES TO THE FINISH OF 12.5 MICRONS AND TOLERANCE OF +2 ON OD & -0 ON ID.
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21203 REV00
3. CASTING MACHINED TO THIS DRAWING SHALL BE USED FOR FABRICATION OF IMPELLER AT BHEL BHOPAL,
4. WT OF CASTING BEFORE MACHINING : 23300 KGS  
WT OF CASTING AFTER MACHINING : 11980 KGS

| REV | DATE | ALTERED | ZONE |
|-----|------|---------|------|
|     |      | CHECKED |      |
| REV | DATE | ALTERED | ZONE |
|     |      | CHECKED |      |
| REV | DATE | ALTERED | ZONE |
|     |      | CHECKED |      |

|                                                               |                               |                                                                                                       |                                |
|---------------------------------------------------------------|-------------------------------|-------------------------------------------------------------------------------------------------------|--------------------------------|
|                                                               |                               | <b>BHARAT HEAVY ELECTRICALS. LTD.</b><br><b>CENTRAL FOUNDRY FORCE PLANT</b><br><b>RANIPUR HARDWAR</b> |                                |
| DEPT. F.DY. TECH.<br>PROJECT AND CUSTOMER NAME<br>BHEL BHOPAL | SCALE N.T.S.<br>WEIGHT IN Kgs | NAME<br>SIGN<br>DATE                                                                                  | TECHNOLOGY NO<br>23609         |
| TITLE<br><b>ROUGH M/C DRG FOR</b><br><b>SKIRT OF IMPELLER</b> |                               | L.S.N<br>23/P R REDDY/23609M                                                                          | NO. OF SHEETS-1                |
| PROJECT AND CUSTOMER NAME<br>BHEL BHOPAL                      |                               | W.D<br>NAVEEN<br>54 18.5.21                                                                           | D.R<br>NK GAURAM<br>54 18.5.21 |
| PROJECT AND CUSTOMER NAME<br>BHEL BHOPAL                      |                               | APPD<br>R LAKRA<br>54 18.5.21                                                                         | NO. OF SHEETS-1                |

0-204-07-21203/M1

22032

### Item Description

|                    |                                    |
|--------------------|------------------------------------|
| Tender Enquiry No  | FF/SC/22032/202200821              |
| Item               | Impeller Skirt Nickel= 3.5% - 4.5% |
| Drg No             | 0-204-07-21203/M1: Rev-00          |
| Quantity           | 04 No                              |
| Delivery Terms     | 6 Weeks/Piece                      |
| befor Machingh Wt  | 23300 KG                           |
| After Machinigh Wt | 11980 KG                           |

### Remarks:-

GRADE CONTAINS NICKEL=3.5-4.5%

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS

PQR & TR AS PER ANNEXURE: 53826/A1

ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING & INCOMING JOB